

Work Order ID ~~74787~~**\*74787\***

Page 1

October 6, 2011 1:37:14 PM

Item ID: D412-630-034

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli Access Step RH Folding

Start Date: 10/06/11 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 10/17/11 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: ~~1110/06~~

Date: 11/10/06 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

**\*100\***

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile &amp; create labels per PPP D412-630-034 CHG003

0.00

0.00

110

**\*110\***

Small Fab

Small Fab

Small Fab

Memo

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M112317

COAT exposed HARDWARE WITH LPS PROCYON

A/R LPS PROCYON BATCH: M114596

0.00

0.00

H. J. M. L. J. 11-12-1  
(4)

EP 11/12/09 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Required Date: 10/17/11 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00				x4			
Quality Control						RH			
130	Pick Kit	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging									
140	QC4- 100% Inspect kits for completeness	0.00							
<b>*140*</b>									
QC	Memo	0.00				x4			
Quality Control						RH			

SP 11-11-29.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Packaging	0.00						11-12-14	(4)
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-034								
	Location: <u>III</u>								
	PPP Rev: <u>III</u>								
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

11-12-14  
(4)

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Parent Item: D412-630-034

**\*D412-630-034\***

Parent Item Name: Heli Access Step RH Folding

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-08 JLM  
IPP rev B ecn1019, added D2807-041 EC verified by:DD  
IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN310C8		Purchased	No			110	Each	28.0000	2	8			
<b>*AN310C8*</b>													
Nut													

Location	Loc Qty	Loc Code
ST324	28	
118091	8	
118378	20	

AN3C21A		Purchased	No			110	Each	52.0000	2	8			
<b>*AN3C21A*</b>													
BOLT													

Location	Loc Qty	Loc Code
ST352	52	
109148	2	
117514	50	

AN8C16		Purchased	No			110	Each	22.0000	2	8			
<b>*AN8C16*</b>													
Bolt													

Location	Loc Qty	Loc Code
ST345	22	
106066	7	
118451	15	

M 119 324 SP  
11-11-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

D2012-107

Manufactured No

110

Each

15.0000

1

4

**\*D2012-107\***

\*\*

SP

Clevis

Location

Loc Qty

Loc Code

ST004

15

71602

15

D2803-042

Manufactured No

110

Each

1.0000

1

4

**\*D2803-042\***

\*\*

SP

Bracket Assembly

Location

Loc Qty

Loc Code

ST149

1

72209

1

D2804-042

Manufactured No

110

Each

3.0000

1

4

**\*D2804-042\***

\*\*

SP

Bracket Assembly

Location

Loc Qty

Loc Code

ST150

3

71566

3

D2807-041

Manufactured No

110

Each

45.0000

2

8

**\*D2807-041\***

\*\*

SP 11-11-29

Door prop

Location

Loc Qty

Loc Code

ST022

40

60540

2

71562

3

73030

10

73920

25

ST023

5

68494

5

8x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Heli Access Step RH Folding

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

D2813 Manufactured No

110 Each 13.0000 2 8

**\*D2813\***

Washer

**\*\* B 75028 SP**

Location Loc Qty Loc Code

ST023 13

69386 1

71169 12

D3395-1 Manufactured No

110 Each 65.0000 4 16

**\*D3395-1\***

Bushing

**\*\* 4x SP**

Location Loc Qty Loc Code

ST052 65

70775 2

71563 63

D3562-042 Manufactured No

110 Each 0.0000 1 4

**\*D3562-042\***

Step Assembly, RH

MS21043-3

**\*MS21043-3\***

Nut

**B 74789 (4x) \*\***

**SP 11/12/07**

Purchased No

110 Each 951.0000 4 16

**\*\* SP 11-11-29**

Location Loc Qty Loc Code

FG 72

103691 72

ST301 879

118077 1

118614 492

118686 386

**16x**

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Shop Packet Print

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Heli Access Step RH Folding

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

MS24665-302

Purchased

No

110

Each

115.0000

2

8

**\*MS24665-302\***

\*\*

Cotter Pin

SP

Location

Loc Qty

Loc Code

ST357

115

117460

115

110

Each

63.0000

2

8

MS24693-C280

Purchased

No

**\*MS24693-C280\***

\*\*

Screw

SP

Location

Loc Qty

Loc Code

ST310

62

118093

12

118612

50

ST318

1

111279

1

110

Each

115.0000

6

24

NAS1515H3

Purchased

No

**\*NAS1515H3\***

\*\*

Washer

SP 11-11-29

Location

Loc Qty

Loc Code

ST277

115

116373

6

118078

6

118384

103

11-24x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QG-Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Heli Access Step RH Folding

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

NAS1515H5L

Purchased

No

110

Each

128.0000

4

16

**\*NAS1515H5I \***

WASHER

\*\*

*M119902 SP*  
*8-30-11*

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

88

111359

4

118614

84

*9-*

*M119902*  
*7x*

NAS1515H8

Purchased

No

110

Each

171.0000

4

16

**\*NAS1515H8\***

Washer

\*\*

*SP 11-11-29*

Location

Loc Qty

Loc Code

ST278

171

111275

4

111411

167

*11x*

AN44C7A

Purchased

No

130

Each

52.0000

1

4

**\*AN44C7A\***

Eyebolt

\*\*

*11x*

Location

Loc Qty

Loc Code

ST362

52

109013

12

111308

40

*119513*

AN4C10A

Purchased

No

130

Each

60.0000

1

4

**\*AN4C10A\***

Bolt

\*\*

*11/12/29*

Location

Loc Qty

Loc Code

ST356

60

112243

30

114523

30

*112243*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

AN4C15A

Purchased

No

130

Each

129.0000

2

8

\*\*

**\*AN4C15A\***

Bolt

Location

Loc Qty

Loc Code

ST358

129

115835

2

118628

27

118706

100

118628

AN4C6A

Purchased

No

130

Each

242.0000

1

4

\*\*

**\*AN4C6A\***

Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

238

116704

15

118451

123

118983

100

118981

AN5C15A

Purchased

No

130

Each

65.0000

2

8

\*\*

**\*AN5C15A\***

Bolt

Location

Loc Qty

Loc Code

ST338

15

118191

15

ST339

50

118267

50

118191 4X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

D2806-1 Manufactured No

130 Each 18.0000 2 8

**\*D2806-1\***

Bushing

\*\*

Location

Loc Qty

Loc Code

ST022

18

72141

18

130 Each 19.0000 2 8

Manufactured No

D2806-3

**\*D2806-3\***

Bushing

\*\*

Location

Loc Qty

Loc Code

ST022

19

70886

1

72138

18

130 Each 7.0000 1 4

Manufactured No

D2810-5

**\*D2810-5\***

Strut

\*\*

Location

Loc Qty

Loc Code

ST265

7

52034

1

71564

6

130 Each 12.0000 2 8

Manufactured No

D3396-1

**\*D3396-1\***

Spacer

\*\*

Location

Loc Qty

Loc Code

ST052

12

69906

12

W/O:		WORK ORDER CHANGES					
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Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

MS21043-4

Purchased

No

130

Each

841.0000

4

16

\*MS21043-4\*

\*\*

11/19/30 S L

Nut

LocationLoc QtyLoc Code

FG

40

104603

40

ST301

801

117793

301

118686

500

MS21043-5

Purchased

No

130

Each

424.0000

3

12

\*MS21043-5\*

\*\*

R

Nut

LocationLoc QtyLoc Code

FG

20

101418

20

ST301

304

112314

204

116548

100

ST314

100

118159

100

NAS1515H4

Purchased

No

130

Each

183.0000

7

28

\*NAS1515H4\*

\*\*

L

Washer

LocationLoc QtyLoc Code

ST277

183

116169

3

117460

29

117735

3

118078

48

118612

100

117460 8x  
118078  
118612 20x

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Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

NAS1515H5

Purchased

No

130

Each

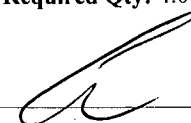
163.0000

7

28

\*\*

*Sy* **\*NAS1515H5\***  
Washer



Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

123

103286

100

118384

23

*118384 20x*

*1183*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

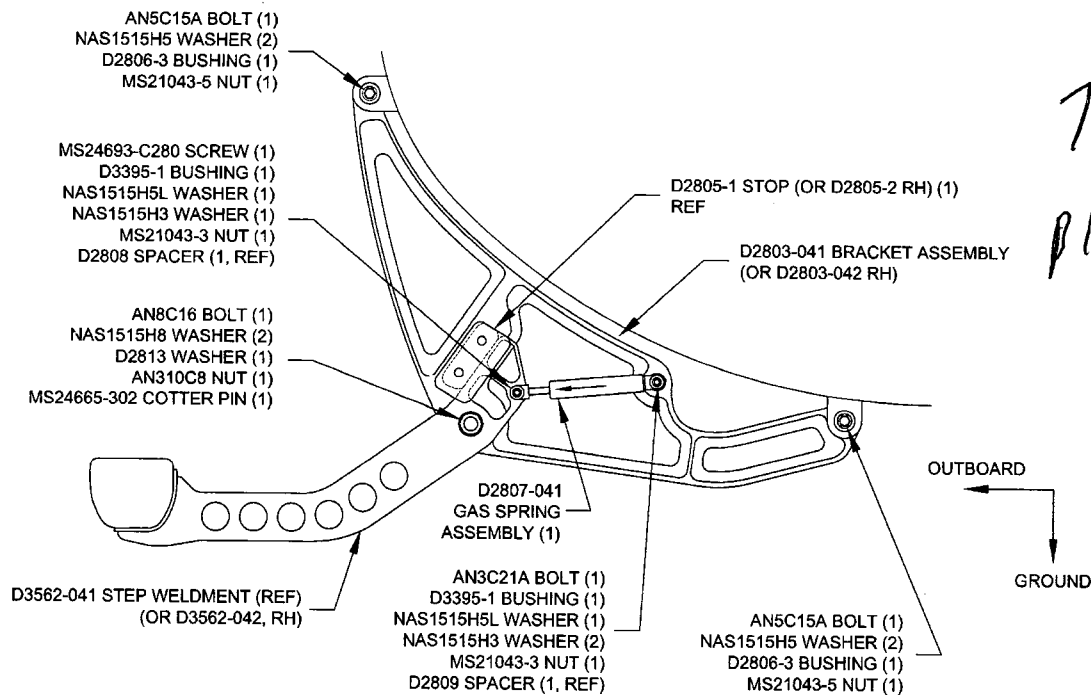
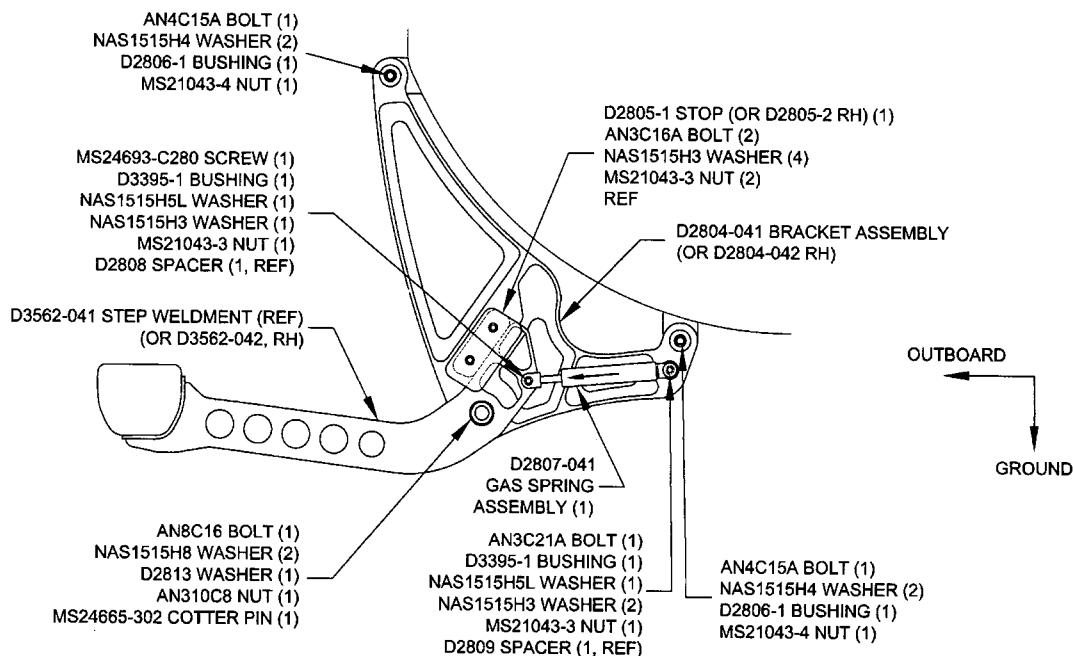
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D412-630-033/-034 Heli-Access-Step™ Installation****FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation  
(View rotated 90° CW)****FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation  
(View rotated 90° CW)**

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Revision: **M**  
Date: 08.12.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

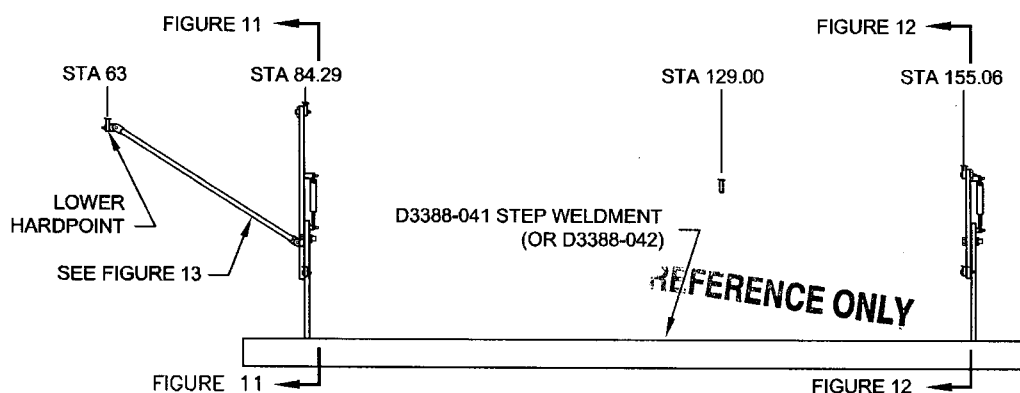
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

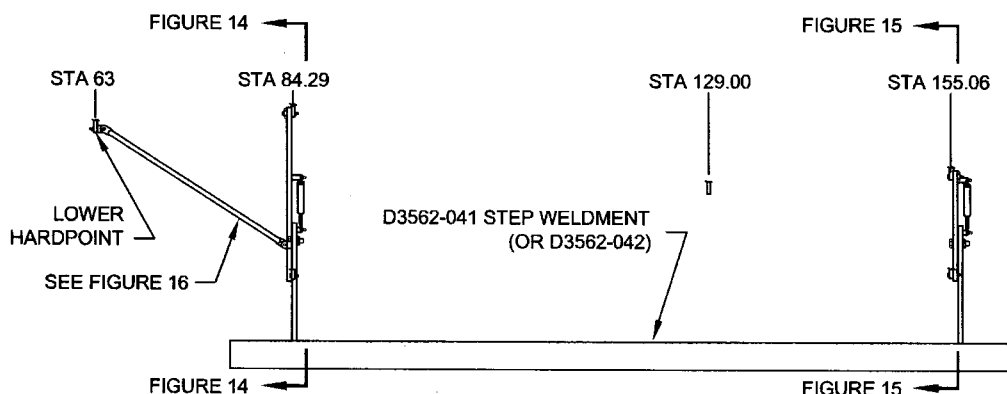
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

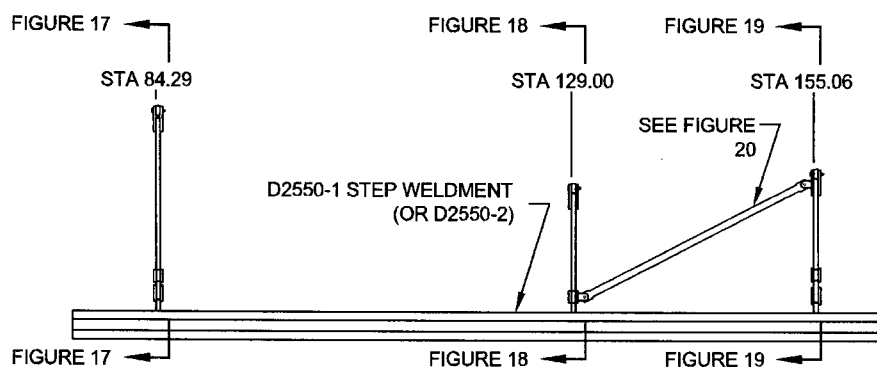
**D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)**  
**D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)**



**FIGURE 3 – D412-630 Heli-Access-Step™ Installations**

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Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

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